

[illegible]

October 30, 2009 10:15:54 AM

**Accept**

**Setup Start**

**Stop**

(b) (5) DPP, (b) (7)(C), (b) (7)(D)

(b) (5) DPP, (b) (7)(C), (b) (7)(D)

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

### Process Plan:

Date: 04-10-30 Tooling:

Date:

**QC:**

Date:

**SPC (Y/N):**

Date:

**Stop**

**Insp.  
Stamp**

Revision Nbr

D3281

Rev D

100

0.00

**1**

## HAND FINISHING THERMOFORMING

## Thermoform

## Memo

0.00

### Thermoforming Machine

## Cut Blanks

110

0.00



## THERMOFORMING MACHINE

## Thermoform

## Memo

0.00

### Thermoforming Machine

Thermoform as per Dwg. D32811 and Folio FTA 011 ☐ Dwg. Rev. 1  
☐ Folio Rev. 3

120

QC2- Inspect parts off machine FAI/FAIB

0.00

[REDACTED]

## Memo

0.00

QC

## Quality Control

**Work Order ID 53317**

October 30, 2009 10:15:54 AM



Page 2

Item ID: D3281-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Floor Protector, Fwd LH

Start Date: 30/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

DL 09/11/04  
X10

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DL 09/11/05  
X10

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) 09/11/07

X10

φ

**Work Order ID 53317**

October 30, 2009 10:15:54 AM



Page 3

Item ID: D3281-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Floor Protector, Fwd LH

Start Date: 30/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
170  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

9/11/19 (102) SQ

09/11/26 HJ

R/09-11-20

# Picklist Print

October 30, 2009 10:15:58 AM

Page 1

Work Order ID: 53317



Parent Item: D3281-1RevD



Parent Item Name: Floor Protector, Fwd LH

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 10.00

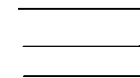
Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No			100	sf	1,550.250	43.3300			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	1550.25	
106751	6.26	
110877	1543.99	



09/11/03  
BB X10

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53317
<b>Description:</b> Floor Protector, Fwd LH		<b>Part Number:</b> D3281-1
<b>Inspection Dwg:</b> D3281	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> <i>DL</i>	<b>Date:</b> 09/11/03
-------------------------------	-----------------------

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.5	✓			
17.1	+/-0.100	17.1	✓			
11.7	+/-0.100	11.625	✓			
0.95	+/-0.030	0.963	✓			
0.25	+/-0.030	0.254	✓			
0.030	Min	0.045	✓			
0.070	Min	0.71	✓			

<b>Measured by:</b> <i>DL</i>	<b>Date:</b> 09/11/05
<b>Audited by:</b> <i>8</i>	<b>Date:</b> 09/11/07
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	

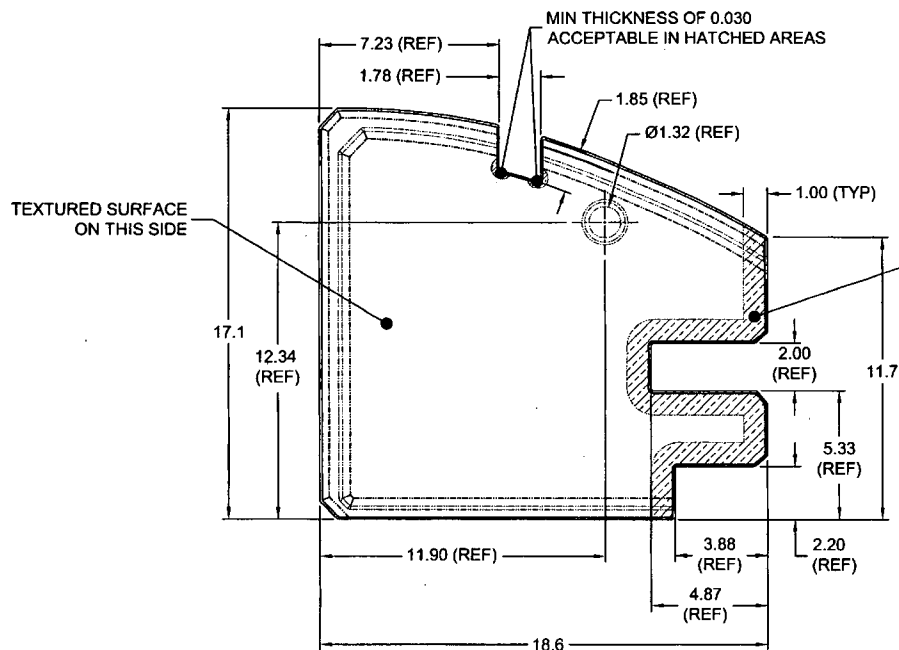
8 7 6 5 4 3 2 1

D

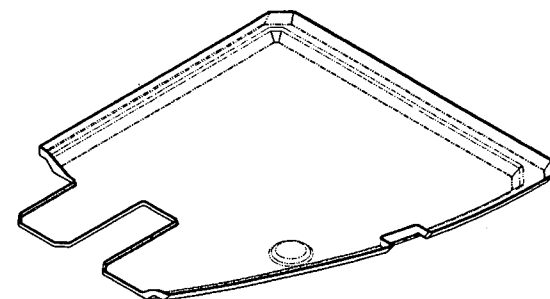
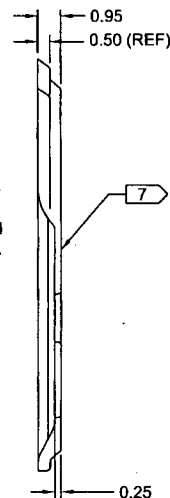
C

B

A



MIN THICKNESS OF 0.030  
ACCEPTABLE IN  
HATCHED AREA



SUBJECT TO  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO  
WITHOUT  
WORK ORDER  
NO. 53317  
PR 09-10-30  
RELEASED  
11.05.04.11 WDU

### D3281-1 FLOOR PROTECTOR

#### D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BA		
CHECKED	13		
MFG. APPR.	BA		
APPROVED	MP		
DE APPR.	4	<b>FLOOR PROTECTOR</b> SCALE NTS	
DATE	08.03.28	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

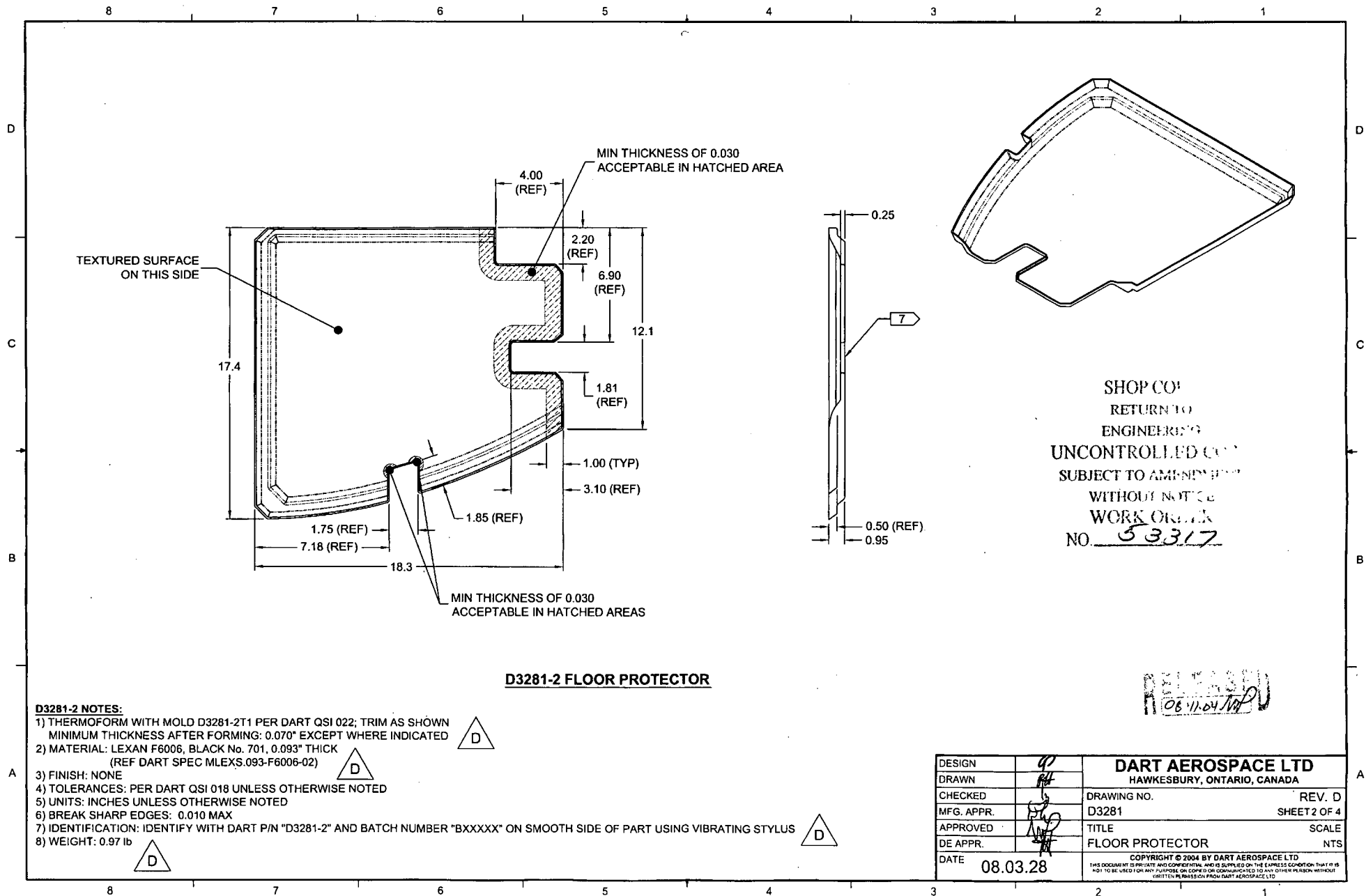
D

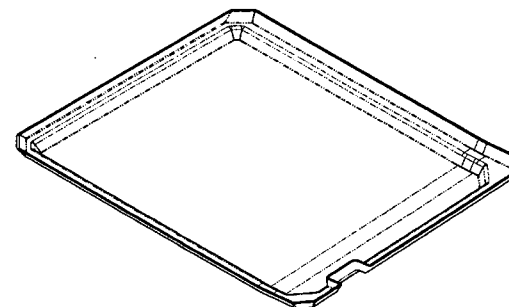
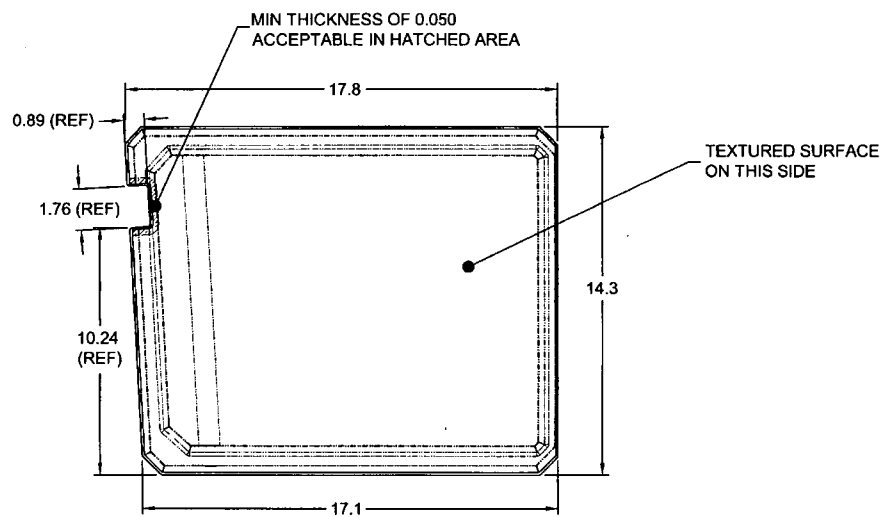
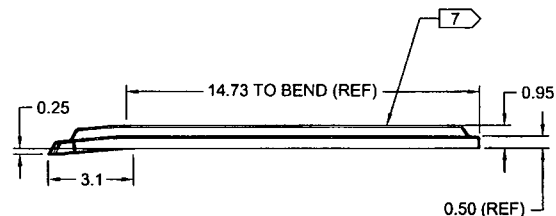
C

B

A

8 7 6 5 4 3 2 1





SHOW COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHOUT NOTICE  
WORK ORDER  
NO. 53317

### D3281-3 FLOOR PROTECTOR

#### D3281-3 NOTES:

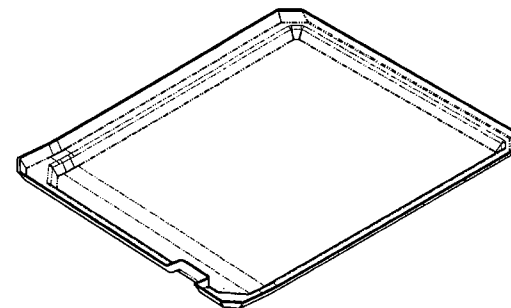
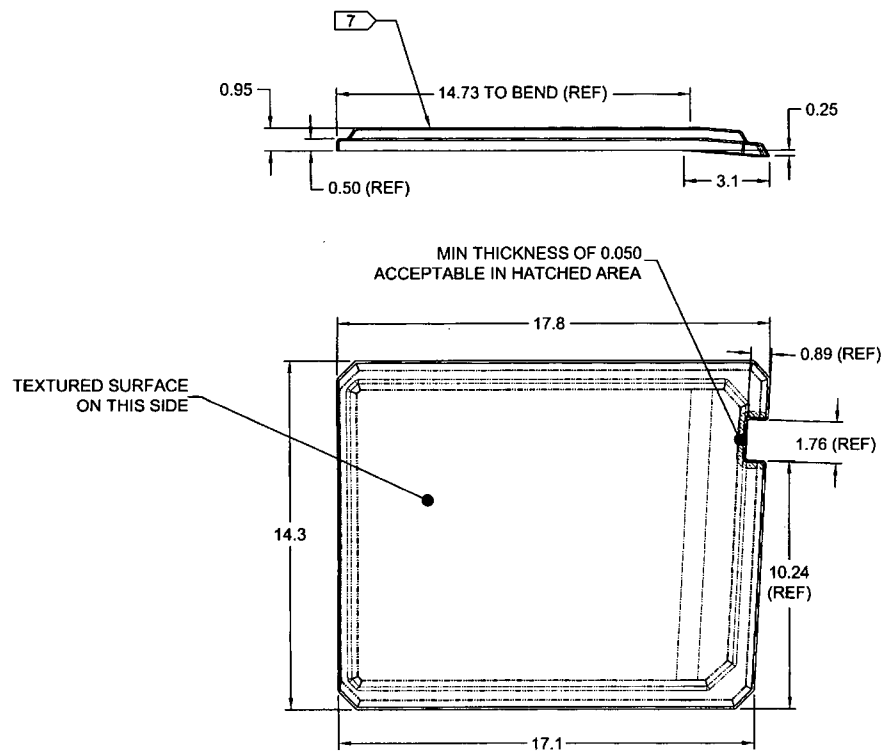
- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb



RELEASED  
08.04.11 MP

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	MD	D3281	SHEET 3 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	FLOOR PROTECTOR	NTS
DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			





SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 53317

### D3281-4 FLOOR PROTECTOR

#### D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

DESIGN	40	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3281	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			